

Work Order ID 60211

Monday, June 28, 2010 3:26:31 PM



Page 1

Item ID:	D2332-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Prop Assembly 6.69" long					
Start Date:	6/28/2010	Start Qty:	10.00	Cust Item ID:		
Required Date:	7/5/2010	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	6/29/10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2332	Rev C1								

100	0.00								
Small Fab									
Small Fab									

Memo

- 1- Cut D2332-7 and D2332-5 to length as per dwg D2332.
- 2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.
- 3- Deburr.

=> m.f 10/08/10

110	0.00								
Brake NC									
Brake NC									

Memo

- Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

=> m.f 10/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

7 M-L 10/08/11

10X

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

D2332-5 - 8/10/08/11 (X10)
D2332-7 - 8/10/08/11 (X10)
D2332-11 - 8/10/08/11 (X10)
D2332-13 - 8/10/08/11 (X10)

(X10) 8/10/08/11

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M108160

EL 10-8-16 (X10)

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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QC	Memo	0.00							
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Quality Control

10.08.16

160	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
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Quality Control

8.06.16

410

P70 ->

170		0.00							
-----	--	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00							
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Small Fab

1- Tumble

2- Assemble as per dwg D2332

8-8-17

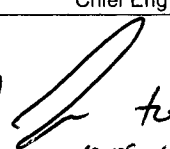
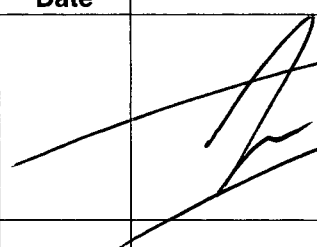
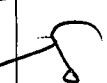
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>60211</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/26/16	#120	Found Qty 12 with a foreign object inside D2332-13. R.C. wasn't cleaned inside enough.		N/A  too minor. 10/28/16				 10/28/16

NOTE: Date & initial all entries

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Item Name: Lid Prop Assembly 6.69" long

Start Date: 6/28/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 10.00

Customer:


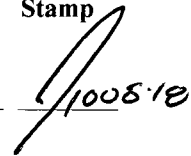



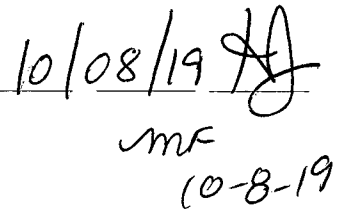
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10			 10/08/18
190  Packaging Packaging	Identify as per dwg & Stock Location: <u>ST512</u> Memo	0.00 0.00							 10/08/18
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 10/08/19 mf 10-8-19

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60211

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.250		Purchased	No			100	f	38.2421	0.1	1.052632			
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304 SS Round bar .250

Location	Loc Qty	Loc Code
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MAT	24	
-----	----	--

114482	24	
--------	----	--

MAT028	14.2421	
--------	---------	--

107387 ✓	14.2421	
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M304TR1.000W.049		Purchased	No			100	f	35.3679	0.43	4.526316			
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304 RD Tube 1.00 x .049W

Location	Loc Qty	Loc Code
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MAT018	35.3679	
--------	---------	--

108756	10.08	
--------	-------	--

111457 ✓	25.2879	
----------	---------	--

M304TR0.500W.035		Purchased	No			110	f	129.5820	1.25	13.15789			
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304 RD Tube .500 x .035W

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	109.617137	
-----	------------	--

114482 ✓	109.617137	
----------	------------	--

MAT014	19.96082	
--------	----------	--

114356	19.96082	
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MAT017	0.004	
--------	-------	--

112800	0.004	
--------	-------	--

m-l
1-052632 10/08/10

4-526316 10/08/10
m-l

13.15789
m-l
10/08/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 60211

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased No 170 Each 214.0000 1 10
Bolt

Location	Loc Qty	Loc Code
ST356	200	
114615 ✓	200	
ST361	14	
108138	6	
111295 ✓	8	

3X m-l 10/08/17
7X 30

AN960JD416L NAS1149D0416J Purchased No 170 Each 283.0000 3 30
Washer

Location	Loc Qty	Loc Code
ST346	283	
110153	283	

30X m-l *
10/08/17

MS21042L4 Purchased No 170 Each 2,771.000 1 10
Nut

Location	Loc Qty	Loc Code
ST300	2771	
113422	68	
114523	28	
114718	675	
114784 ✓	2000	

10X m-l
10/08/17

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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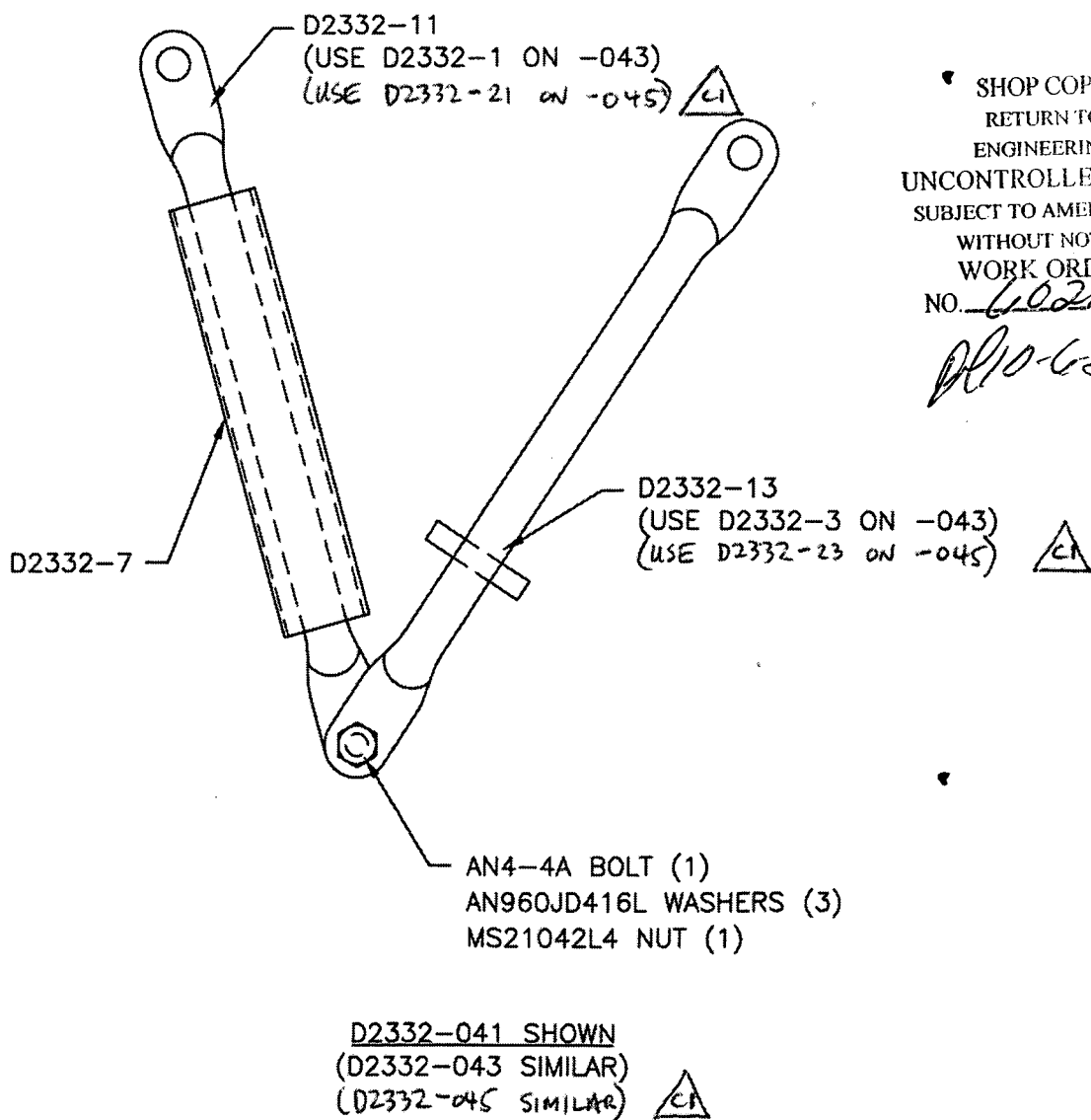
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DESIGN <i>#</i>	DRAWN BY <i>KS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>#</i> <i>4/</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *#*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *6024*

010-629

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

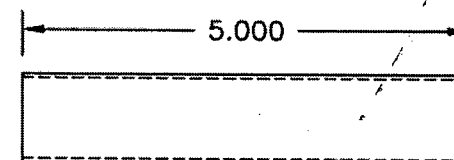
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DART

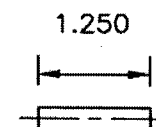


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	TITLE LID PROP ASSEMBLY	REV. C
	DRAWING NO. D2332	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE -041 PROP 6.69" LONG (END)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (INT)
		ADD -045 PROP 7.25" LONG

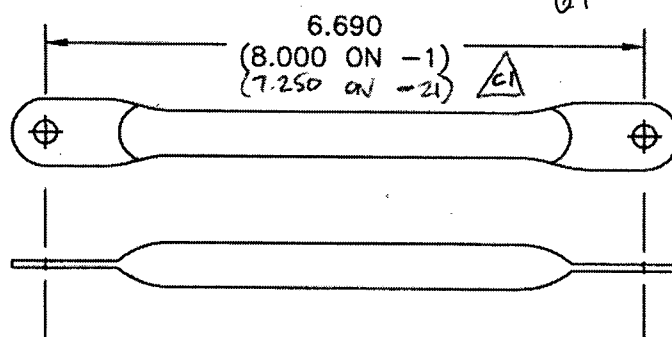


D2332-7 LOCKING COLLAR

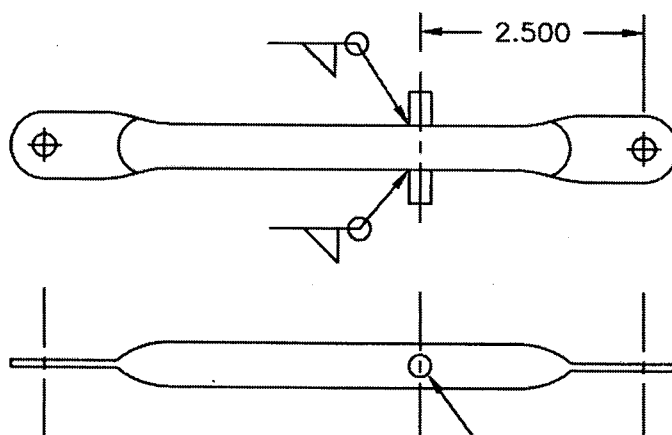
w/o 6024



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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